



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2535

Job Sheet 171790



Part No: D2535

Job Qty: 50 ea

Part Name: Spring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV A IPP A 99.04.19 New Issue (From hand written IPP) DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	50 pcs		2/19/18	0.00	0.00	Purchasing		AP 18/03/18
110	Packaging	50 pcs		2/19/18	0.00	0.00	Packaging2		AP 18/03/18
120	QC	50 pcs		2/19/18	0.00	0.00	QC6		38
130	Packaging	50 pcs		2/19/18	0.00	0.00	Packaging3	5008	MAR 06 2018
140	QC21-SA	50 Ea		2/19/18	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 059052 - Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring
Descriptions: 110 - Ensure Material Release Note is attached
120 - Check dims to dwg

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3-86

MAR 07 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2535P	Spring	50 pcs (1 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2535P	50	0	0

Part Specifications

Specifications could not be found.

Plex 2/8/18 2:19 PM Dart.Gagnon.Michelle

Container No.



Spring

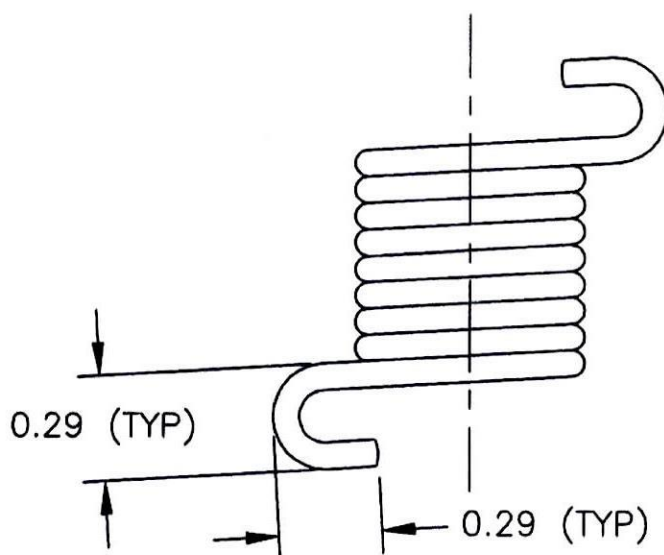
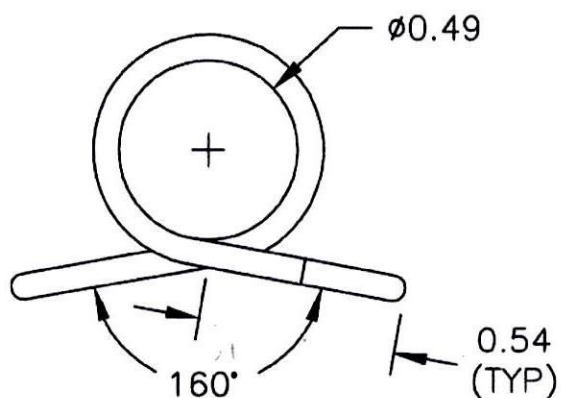
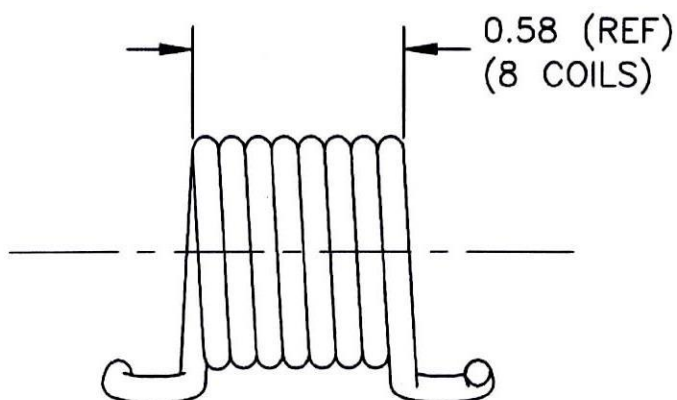
PART NO: D2535
Serial No/Batch: S047896
Revision:
Operation: Packaging
Change No:

Mfg Date: 03/05/18
Job No: 171790



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08	TITLE SPRING SPEC CONTROL		SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Dart Aerospace Ltd.
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PURCHASE ORDER PO039052

Supplier: VIC002-VC
Victory Spring Ltd.
#2 6104 - 82 Ave.
Edmonton
AB
T6B 0E7 Canada
Phone: 866 230 5312
Fax: 866 230 5338

PO No: PO039052
PO Date: 2/15/18
Due Date: 3/1/18
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Phone:

E-MAILED
FEB 15 2018
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Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D2535P		Spring As per Dwg D2535 Rev. A	Firmed	3/1/18	50 pcs	0 pcs 50K	50 pcs	\$4.74/pcs ATC 2/03/18	\$237.00
Line Item Note job# 171790										Grand Total: \$237.00

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Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace Ltd.	DATE: 2/28/2018
PART/DRAWING #: VIC 1533 / D2535P	PO # PO039052
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 50
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03	
PROPERTIES:	
<u>Chemical</u>	<u>Physical</u>
Carbon: (C) 0.065	Size: 0.072"
Chromium: (Cr) 18.050	
Copper: (Cu) 0.420	Tensile PSI: 268,300 / 275,000
Manganese: (Mn) 1.190	
Molybdenum: (Mo) 0.330	
Nickel: (Ni) 8.020	
Phosphorus: (P) 0.029	Heat # KNAX00924
Silicon: (Si) 0.320	
Sulphur: (S) 0.001	
Mill Source: Gibbs Wire	

Certified by: Jeremy Burrowes - QA

Victory Spring Ltd. certifies this to be a true & accurate copy of the original contained in the company records.

CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 2/28/2018
PART/DRAWING #: D2535P / VIC 1533	PO # PO039052
DESCR: Torsion Spring	QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS302	yes	
Material diameter	0.07	0.072	
Coil I.D.	0.490	.489"	
Coil O.D.		.634"	
Number of Coils	8 ref	7.9	
Overall Length		1.109	
End Type	per dwg	yes	
Helix	RHW	RHW	

COMMENTS

Mill Certificate attached: Yes
Material Heat Number: KNAX00924

Inspected by: *Jeremy Burrowes*